

Work Order ID 122902

Tuesday, July 29, 2014 2:25:34 PM

122902

Page 1

Item ID: D4324-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Armrest Weldment
Start Date: 7/29/14 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 7/29/14 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: WM Date: 7/30/14 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4324	B								

100 Weld per dwg A/R S.S. rod Batch: M123823 0.00

100

Large Fab Memo 0.00

Large Fab

*5 15-04-29 MAL

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00

Quality Control

5 15-5-5 DAS 50 9-89

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.00

Quality Control

5 15-5-5 DAS 50 9-89 DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Tuesday, July 29, 2014 2:25:34 PM

Page 1

Work Order ID: 122902

122902

Parent Item: D4324-041

D4324-041

Parent Item Name: Armrest Weldment

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4324-1		Manufactured	No			100	Each	5.0000	1	4			

D4324-1

Base Plate

**

Location

Loc Qty

Loc Code

ST102

5

117567 x 5

5

x 5

15-04-29 MAL

D4324-5

Manufactured No

100

Each

6.0000

1

4

D4324-5

Tube

**

Location

Loc Qty

Loc Code

WA001

6

116634 x 5

6

x 5

15-04-29 MAL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

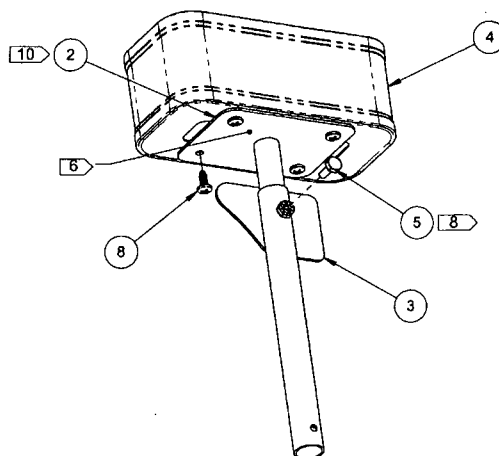
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 182903
7/30/14 wjm



D4324-011 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16) 

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.83 lbs
 - 8) INSTALL HARDWARE HAND TIGHT ONLY
 - 9) BAG LOOSE HARDWARE
 - 10) CENTER D4324-041 ON D4324-045 AS SHOWN

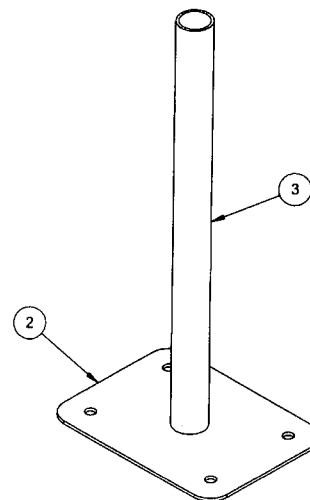
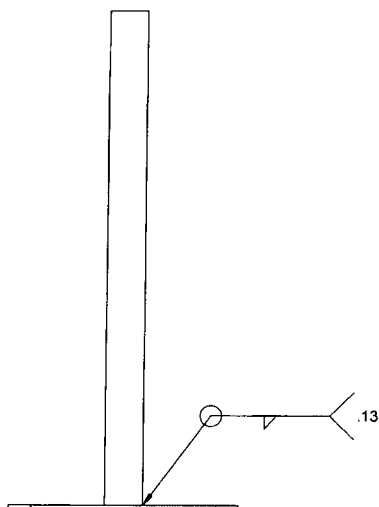
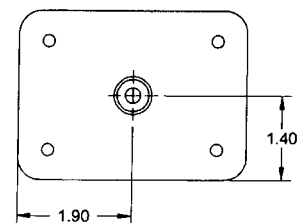
ITEM	QTY -011	P/N	DESCRIPTION
1	X	D4324-011	ARM REST ASSEMBLY
2	1	D4324-041	ARM REST WELDMENT
3	1	D4324-043	ARM SUPPORT ASSEMBLY
4	1	D4324-045	CUSHION ASSEMBLY
5	3	AN3-4A	BOLT
6	1	AN3-12A	BOLT
7	3	MS21075L3	NUT PLATE
8	4	MS51861-45C	SCREW
9	3	NAS1149F0332P	WASHER
10	1	NAS1149F0363P	WASHER

RELEASED
2014-04-23

B	ADD D4324-011 (ZN B4-1) & D4324-045 (ZN B4-4); REVISE D4324-041 NAME (ZN B4-2, D4-2); ADD Ø0.204 HOLES (ZN D5-5) & Ø0.25 HOLE (ZN D4-5); 6.30 WAS 6.95 (ZN C5-7); REVISE IDENTIFICATION NOTES; REF PAR13-319	RF	14.04.03
A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D4324 REV. B SHEET 1 OF 7	
CHECKED	DC	TITLE ARM REST ASSEMBLY SCALE NTS	
MFG. APPR.	DD	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
APPROVED	HS	DATE 14.04.03	
DE APPR.	DS		

APPROVED

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4324-041	ARM REST WELDMENT
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST WELDMENT
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) B

NOTES:

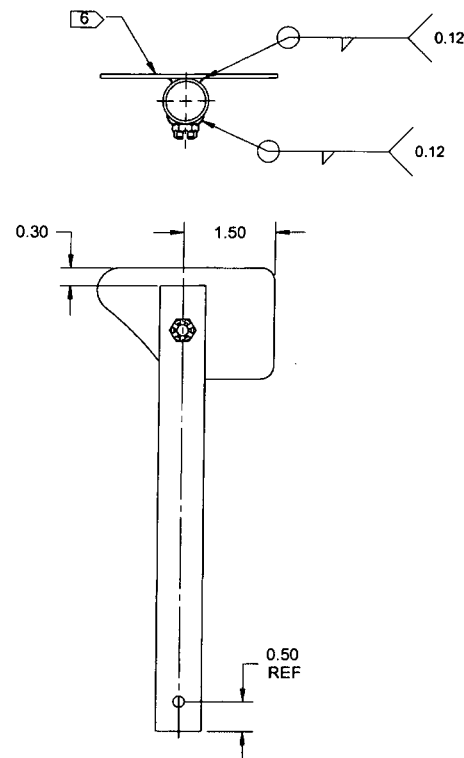
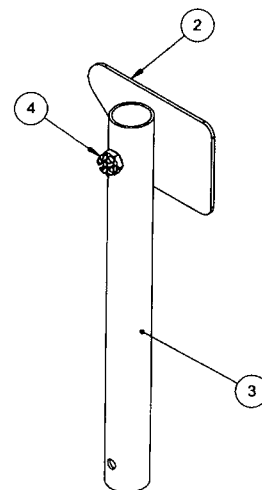
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) WELD PER DART QSI 004

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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2014-04-23

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle$ B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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2014-04-23

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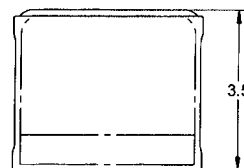
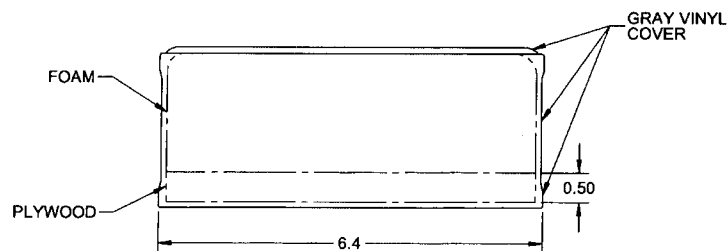
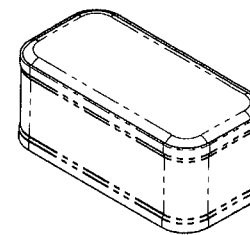
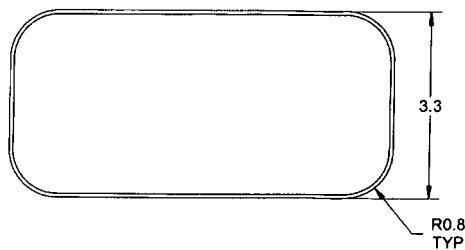
1

D

C

B

A



D4324-045 CUSHION ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

RELEASED
2014-04-23
WP

NOTES:

- 1) MATERIAL: AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4324	REV. B
MFG. APPR.	DD		SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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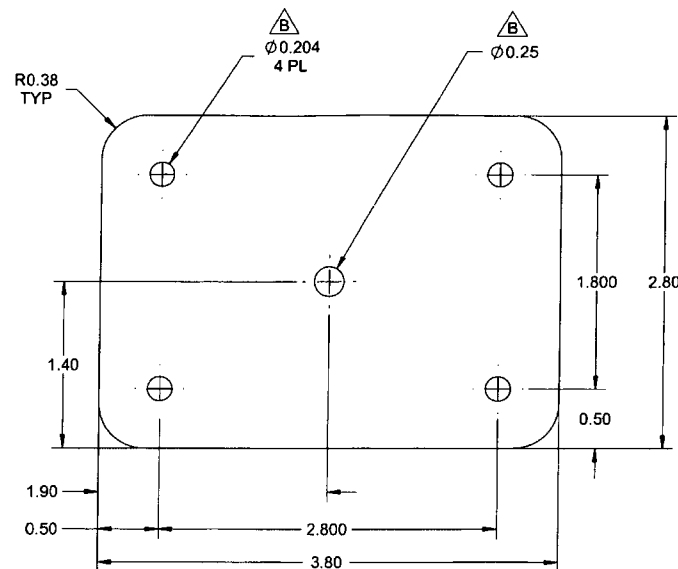
4

3

2

1

A



D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle$ B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 5 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE	14.04.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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2014-04-23

8 7 6 5 4 3 2 1

D

C

B

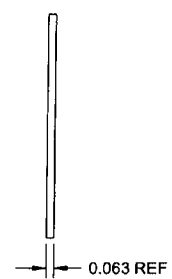
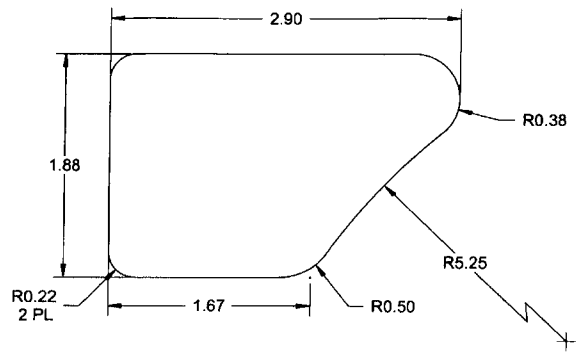
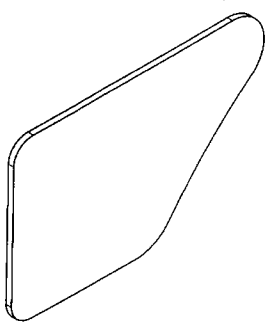
A

D

C

B

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
 ANNEALED
 2B FINISH
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC. M304S16GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.08 lbs

RELEASED
2014-04-23
WDP

RELEASE
2014-01-23

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4324	REV. B
MFG. APPR.	DD		SHEET 6 OF 7
APPROVED	HS	TITLE ARM REST ASSEMBLY	SCALE
DE APPR.	DS		NTS
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8 7 6 5 4 3 2 1

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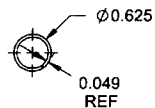
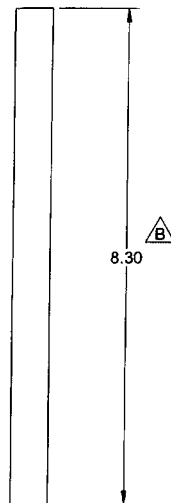
3

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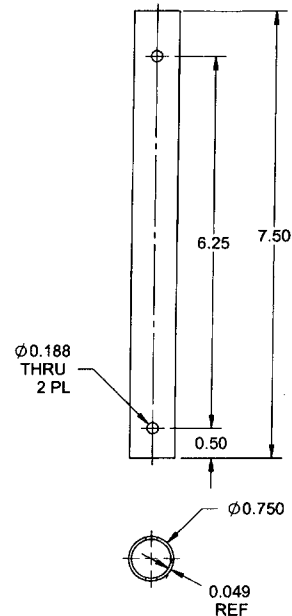


D4324-5 TUBE



D4324-5 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4324-5 = 0.21 lbs
D4324-7 = 0.23 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4324
MFG. APPR.	DD	
APPROVED	HS	TITLE ARM REST ASSEMBLY
DE APPR.	DS	
DATE	14.04.03	SCALE NTS

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